

**Technical Data:**

Issued: October 2010  
Revision:2 . July 2020, Page: 1

**EP 170/EPC 124**

Clear Low Viscosity Room Temperature Curing Epoxy

**Product Description**

EP 170/EPC 124 is a clear, unfilled, low viscosity, two-component room temperature curing epoxy compound with high penetration capability.

**Features & Benefits**

- Low viscosity
- Easy impregnation of reinforcement materials
- High mechanical properties
- Can be pigmented easily

**Applications**

Production of Glass/Epoxy or Carbon/Epoxy composite parts using Resin Transfer Molding, wet lay-up, pressure molding and infusion processes at room temperature

**Typical Uncured Properties**

**Note:** The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Base Resins	Base (A) Hardener (B)	Epoxy Resin Amines
<b>Appearance/Color</b>	A B	Clear Clear
<b>Viscosity, cP</b> per ASTM-D-2393	A @ 25°C B@ 25 °C	800 – 1200 150000-250000
<b>Density, g/cm<sup>3</sup></b> @ 25°C	A B	1.15 ± 0.03 0.96 ± 0.03
<b>Mix Ratio (A:B)</b>	By weight	100:28

**Mixing Instruction**

The components must be weighed accurately according to recommended mixing ratio and mixed thoroughly scraping both sides and bottom of the mixing container to obtain optimal properties. Smaller mix quantity is recommended to prevent considerable exotherm. Vacuum de-airing is recommended to remove entrapped air. De-air mixture at 5-10 mmHg until most of the bubbling has ceased.

**Technical Data:**Issued: October 2010  
Revision:2 . July 2020, Page: 2**EP 170/EPC 124**

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**Recommended Curing Schedule**24 hr @ 25°C + 4hr @ 60°C or  
8hr @ 25°C + 8hr @ 60°C**Typical Cured Properties****Note:** The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

<b>Color</b>	Clear
<b>Gel-time</b> , 3mm layer @ 25°C, hr	2 – 2.5
<b>Gel-time</b> , 100g @ 25°C, min	30-50
<b>De-mold</b> @ 25°C, hr	6-8
<b>Hardness</b> , ASTM-D-2240, Shore D (after 7days)	80-85
<b>Tensile Strength</b> , ASTM-D-638, MPa	50-70
<b>Tensile Elongation</b> , ASTM-D-638, %	3-6
<b>Flexural Strength</b> , ASTM-D-790, MPa	90-120
<b>Flexural Modulus</b> , ASTM-D-790, MPa	2700-3300
<b>Service Temperature</b> , °C	-40 to 90

**Storage and Handling**

The shelf life of the EP 170 is 12 months at 20-35°C.  
For the best results, store in tightly closed original containers.  
Certain resins and hardeners are susceptible to crystallization. If crystallization occurs, warm the container to 50-60°C until the crystals have dissolved.  
Stir and allow content to cool to room temperature before use.

**Packaging**

Packaging sizes are available from 1L up to 18L pails.

**Limitation of Liability**

Except where prohibited by law, Polymer-G and seller will not be liable for any loss or damage arising from the Polymer-G product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.

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